

Abstract of the Disclosure

A method for manufacturing an electrical cable provides an electrical cable suitable for use in heating wells. An elastomeric jacket is extruded over insulated conductors. A stainless steel plate is rolled around the jacket to form a cylindrical coiled tubing having a seam. The seam is 5 welded, then the tubing is swaged down to a lesser diameter to cause the tubing to frictionally grip the jacket. A recess may be formed in the jacket adjacent the seam to avoid heat damage from the welding process.